

Monday, 08/06/2009 11:13:04 AM

User:

Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 48404
 Estimate Number : 14005
 P.O. Number :
 This Issue : 08/06/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run :
 Written By :
 Checked & Approved By : Mr 09-06-08
 Comment : Est Rev:A 09.06.08 new issue DD verified by:EC

Drawing Name : GAS SPRING BRACKET ASSY
 Part Number : D3953041
 Drawing Number : D3953 PROTO
 Project Number : N/A
 Drawing Revision : PROTO
 Material :
 Due Date : 15/06/2009 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S11GA

304/316 0.125 Sheet



Comment: Qty.: 0.0408 sf(s)/Unit Total: 0.0817 sf(s)

M304 SS 0.125" thick Sheet

batch: 111018

B 96-11

B 96-9

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg

Dwg Rev: PROTOProg Rev: TYPE

2- Deburr if necessary

B 96-11

B 96-9



3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 96-11

B 96-9

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

09-06-09

See last page

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg

SB 09/06/10

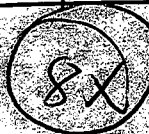
SB 07/06/08

5.1 re-drill 11/16.189 to draw after bending.

deburr.

M-H

09/06/10



Date: Monday, 08/06/2009 11:13:04 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING BRACKET ASSY

Job Number: 48404

Part Number: D3953041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Inspected 8

Inspected 9



Comment: INSPECT WORK TO CURRENT STEP

7.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer Bushing 3 142 74

09-06-09

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2327-3 to length (0.565) as per dwg D3953

2- Weld as per dwg.

09-06-09

2

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-06-17

PD 09-06-09

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock Location: _____

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion:



00271

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D350-607-057

Job #: 00271

Date: 09.06.04

Product Name: Gas Spring Kit

Requested By: AJS

Design Manager Approval: 


| Quantity | Part Number | Category | Description | Drawing Date | Material Cert Req'd? | Due Date | Comments | Date Completed |
|----------|-------------|----------|--------------------|--------------|----------------------|----------|--|----------------|
| 2 | D3953-041 | | GAS SPRING BRACKET | 09.06.04 | NO | 09.06.09 | For function test only no certs required | |
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| DART AEROSPACE LTD | Work Order: 48404 |
| Description: GAS SPRING BRACKET Assy | Part Number: D3953-1 |
| Inspection Dwg: D3953-1 Rev: prototype | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| | | | |
|----------|----------------------|--------------------------|------------------|
| X | First Article | <input type="checkbox"/> | Prototype |
|----------|----------------------|--------------------------|------------------|

[illegible]

| | | |
|-----------------------|---|---------------------|
| Measured by: B | Audited by:  | Prototype Approval: |
| Date: 9-6-9 | Date: 09/06/09 | Date: |

| | | | | |
|-----|------|-----------|------------|----------|
| Rev | Date | Change | Revised by | Approved |
| A | | New Issue | KJ/JLM | |

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D350-607-057

Job #: 00271

Date: 09.06.10

Product Name: Gas Spring Kit

Requested By: AJS

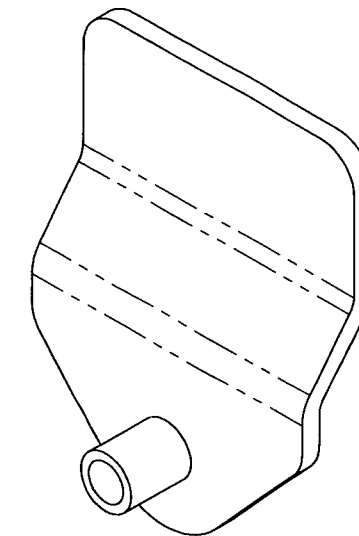
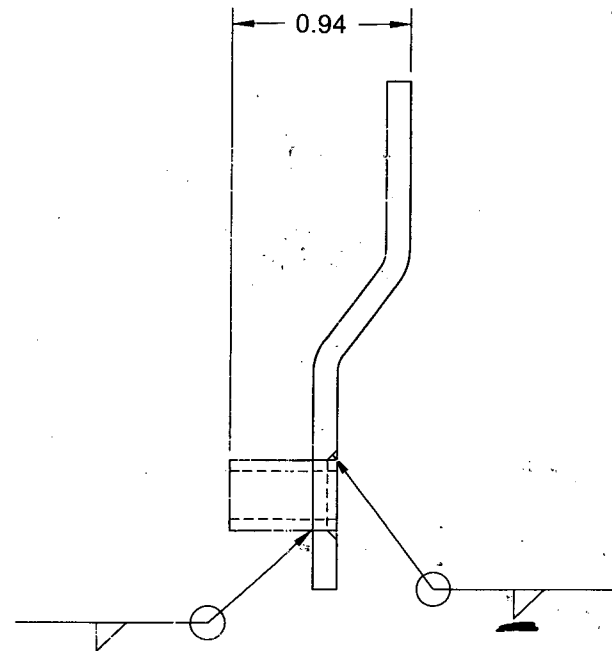
Design Manager Approval: 

| Quantity | Part Number | Category | Description | Drawing Date | Material Cert Req'd? | Due Date | Comments | Date Completed |
|----------|-------------|----------|--------------------|--------------|----------------------|---------------------------------|--|----------------|
| 4 | D3953-041 | | GAS SPRING BRACKET | 09.06.10 | NO | 09.06.10 09.06.10 | For function test only no certs required | |
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D3953-1
GAS-SPRING BRACKET

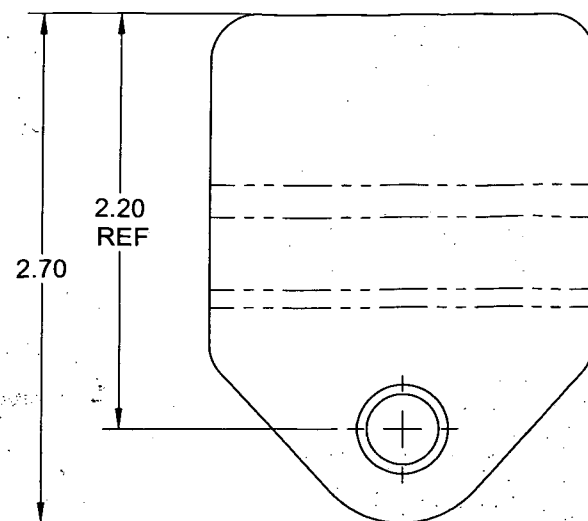
D3953-3
GAS-SPRING BUSHING

D3953-041 GAS-SPRING BRACKET ASSY

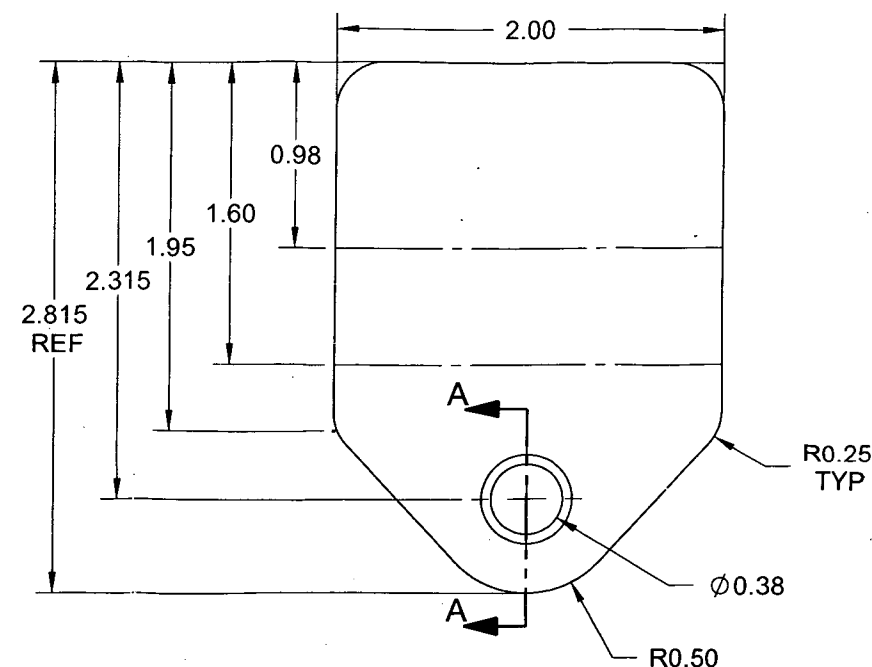
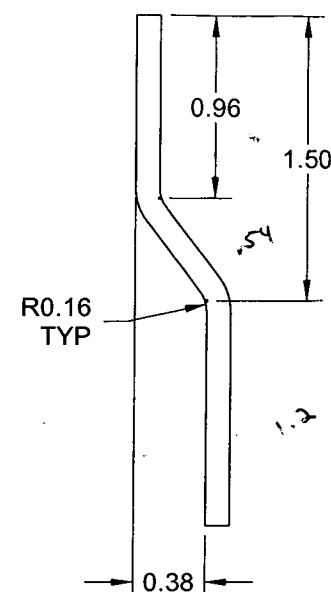


PROTOTYPE
155 09.06.04

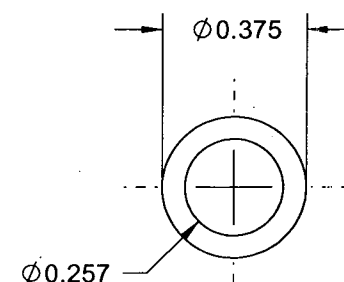
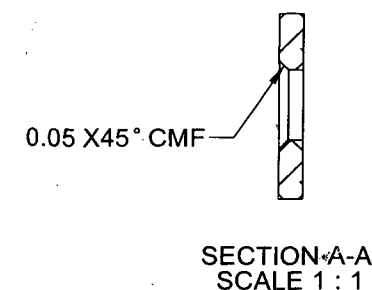
| REV. | DESCRIPTION | | BY | DATE |
|------------|-------------|--|--|------|
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | | | | |
| CHECKED | | DRAWING NO. | REV. A | |
| MFG. APPR. | | D3953 | SHEET 1 OF 2 | |
| APPROVED | | TITLE | SCALE | |
| DE APPR. | | GAS-SPRING BRACKET ASSY | NTS | |
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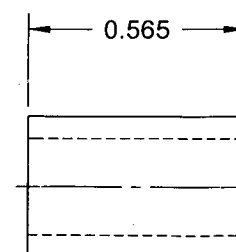
D3953-1 GAS-SPRING BRACKET



D3953-1F FLAT PATTERN



D3953-3 GAS-SPRING BUSHING



NOTES D3953-1:

- 1) MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
PER AMS 5513 OR AMS 5524
REF DART SPEC M304S
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs

NOTES D3953-3:

- 1) MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING
REF DART SPEC M304TR
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

| | | | |
|------------|-----------------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3953 | SHEET 2 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GAS-SPRING BRACKET ASSY | NTS |
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PROTOTYPE
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